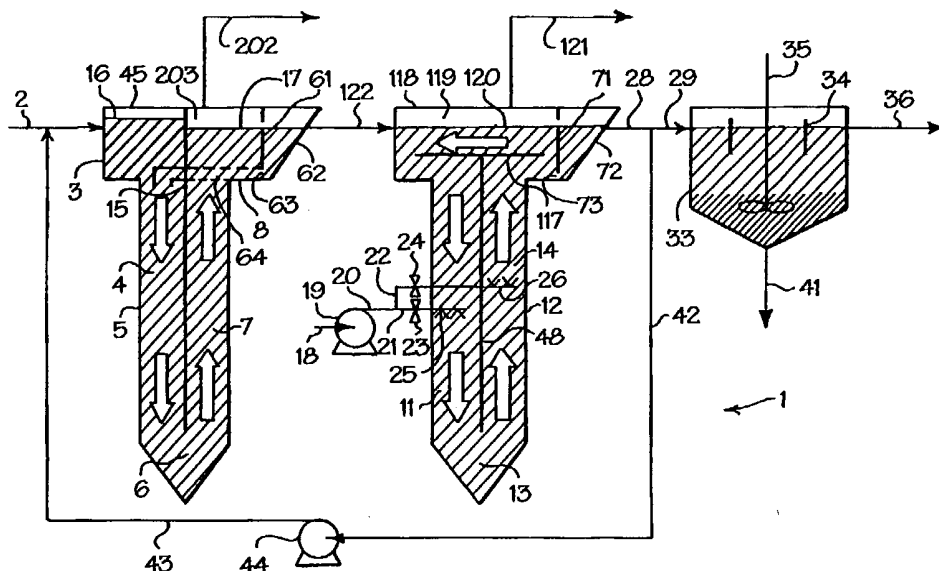




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(54) Title: LIQUID EFFLUENT TREATMENT PROCESS AND PLANT



(57) Abstract

The invention relates to an effluent treatment process and to a plant for treating effluent. The plant comprises a pair of elongate vessels (5, 12), one vessel (12) being for aerobic and the other (5) being for anoxic metabolism of effluent by microorganisms in the form of biomass-coated particles, each vessel having a downcomer zone (4, 11) and a riser zone (7, 14). The first riser zone (7) of the vessel (5) for anoxic metabolism communicates with the downcomer zone (11) of the vessel (12) for aerobic metabolism.

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LIQUID EFFLUENT TREATMENT PROCESS AND PLANT

The present invention relates to a liquid effluent treatment process and to a plant for treating a liquid effluent such as waste water.

5 US-A-4552663 describes a process for the removal of ammoniacal nitrogen in the BOD sorption zone of a waste water treatment plant. The BOD sorption zone A, which may be provided with a blanket of nitrogen, comprises a tank partitioned to provide two or more liquid treating
10 sections in order to approximate plug flow of the liquid through the BOD sorption zone A. Liquid from zone A is discharged into the BOD oxidation zone B and is aerated therein. Aeration in each liquid treating section of zone B is proposed using spargers for the purpose. From
15 zone B the liquid passes to a sedimentation tank from which settled sludge is recycled to BOD sorption zone A.

In US-A-3953327 it is proposed to treat sewage by anoxic denitrification while supplying methanol as food for bacteria, followed by stabilisation by aeration and
20 sedimentation. Resulting sludge is recycled to the denitrification step and separated, relatively clear effluent is removed from the process.

A conventional Deep Shaft™ waste water treatment plant is described in GB-A-1473665. Such a plant
25 includes a basin, a riser and a downcomer whose upper ends communicate with each other and with the basin and whose lower ends communicate with each other, as well as circulating means for circulating an effluent, such as sewage, around the system and means for supplying an
30 oxygen-containing gas to the effluent in the downcomer. The downcomer is of a length such that the oxygen transfer rate into the effluent is at least 0.1 kg O₂/hr/m³. At start up, air is injected into the riser

causing its upper section to act as an air-lift pump. When the effluent is circulating at a suitable velocity, e.g. at least 1 metre/sec in the downcomer, the proportion of air which is supplied to the downcomer is increased. Eventually circulation can, if desired, be maintained by supplying air only to the downcomer. The point of injection of air into the downcomer and into the riser is preferably at a position between 0.1 and 0.4 times their total length below the level of the effluent (e.g. sewage) in the basin. Thus when the system extends from 150 to 250 metres below the level of effluent (e.g. sewage) in the basin, air is injected 15 to 100 metres below this level. It is further preferred that air injection takes place at a position more than 30 metres below the level of sewage or other effluent in the basin.

A further description of such a plant can be found in an article by B. Jones in Waste Management & the Environment, Vol 5(3), June 1995, pages 44 and 45.

The practical depth of the shaft in commercial plants, of which there are now more than 70 operating throughout the world, is from 50 to 150 metres. If air is injected into the downcomer 35 metres down a 100 metre shaft, then the path length for the air supplied to the downcomer is 165 metres, giving a contact time of around 3 minutes, compared with about 15 seconds in a conventional diffused air process. Most bubbles dissolve before reaching the bottom of the shaft. Because of the greater solubility of oxygen at the bottom of the shaft, due to the increased hydrostatic pressure, there is a large driving force for oxygen transfer. This has been shown to result in oxygen transfer figures of 3 kg $O_2/m^3/hr$ compared to 0.05 to 0.2 kg $O_2/m^3/hr$ for more conventional processes. This characteristic allows a

Deep Shaft™ plant to treat strong wastes at an increased loading rate, expressed as the food/microorganism (f/m) ratio. Absorption efficiency of oxygen can reach 80% in a Deep Shaft™ plant compared with 15% in a diffused air process. These factors, plus the high turbulence of the liquid in the shaft, are the main cause of the high power efficiencies observed in the shaft (3 to 4 kg O₂/kWhr compared to 1 kg O₂/kWhr in a conventional process). Another advantage of the use of a Deep Shaft™ plant is that the high velocities (1 to 2 m/sec) ensure that solids do not settle out in the shaft, making primary settlement unnecessary.

Further details of Deep Shaft™ plants can be found in an article by D. A. Hines et al. in I. Chem. E. Symposium Series No. 41 at pages D1 to D10.

Bacteria in the liquid effluent circulating in the plant metabolise organic and certain inorganic molecules present in the effluent. Many types of effluent may be treated in this way. For example, domestic sewage, food waste, waste paper and industrial effluent from the textiles industry, the plastics industry and the steel industry are all treated currently by commercial plants of this type.

In operation, a conventional Deep Shaft™ plant is initially seeded with a load of activated sludge from a sewage plant. Once circulation of the effluent is initiated, the enhanced aeration of the system provides suitable conditions for the aerobic bacteria to thrive.

In the downcomer the bubbles of air entering the system tend to rise against the flow of the liquid effluent. However, once the liquid circulation rate reaches a value greater than the upward velocity of an air bubble, air bubbles entering the downcomer are drawn

downwards by the moving effluent until, eventually, the air stream to the riser can be cut off, with air then being supplied to the system only in the downcomer. Because of the voidage in the effluent in the riser the specific gravity of the mixture of air and effluent in the riser can be as much as 0.20 g/cm³ less than that of the unaerated liquid effluent at the top of the downcomer. Hence the circulation of effluent through the plant is assisted by the hydraulic pressure differential above the air supply point in the downcomer, due to the significant difference in specific gravity between the air bubble-containing aerated effluent in the riser and the non-aerated effluent at the top of the downcomer.

A conventional plant of this type is adequate for removal of molecules susceptible to metabolism by aerobic bacteria. However, there are limitations on the effectiveness of such a plant in liquid effluent and waste water treatment. In particular, aerobic bacteria are not capable of digesting nitrates which may be produced in large quantities inside the shaft as a product of the metabolism by the aerobic bacteria of ammonia. Ammonium ions are very common in many types of effluent, including domestic waste and sewage. Ammonia is also malodorous at high concentrations and toxic to aquatic organisms even in low concentrations; accordingly it is required to be removed from effluents by legislation in many countries. In addition it has a high biological oxygen demand (BOD). Although nitrates do not present the same problems as ammonia, their removal from waste water is highly desirable and is legislated for in some countries. Nitrates are natural fertilisers and their release into the environment, particularly in still waters, such as lakes and reservoirs, facilitates algal

growth. Excessive nitrate release into environmental waters can give rise to a phenomenon known as eutrophication in which an aquatic environment becomes subject to excessive plant and algal growth and is eventually starved of important nutrients such as phosphorus because of intense algal bloom. Starvation and death of the algae population then follows and the decay of their cell material by aerobic metabolism depletes the water of oxygen, so that fish and other oxygen-dependent organisms are destroyed.

To combat the problem of nitrates in effluent which, when treated, is to be released into the environment, anoxic bacteria are conventionally used to reduce nitrates to nitrogen gas. These anoxic bacteria are provided in an anoxic tank upstream of the Deep Shaft™ equipment. A minor stream of effluent from the Deep Shaft™ equipment is generally recycled to the tank. However, such a system suffers from a number of disadvantages. In particular, the residence time of the recycled effluent in the anoxic tank is long enough for any aerobic bacterial activity in the recycle stream to be inhibited. Furthermore, it is very difficult to prevent fumes of noxious chemicals such as fatty acids escaping from the tank. Such escapes often give rise to the characteristically unpleasant odour in the environs of a liquid effluent treatment plant such as a waste water treatment plant.

In Japanese Kokai No. 4-338,293 there is described a process in which immobilised microorganisms are used in a Deep Shaft™ plant. This process has been offered commercially as the so-called Trends System or Takenaka Refined Shaft System.

It is an object of the present invention to provide

an improved form of liquid effluent treatment plant. It is a further object of the invention to provide an effective and environmentally acceptable method of effluent treatment.

5 According to the present invention there is provided an effluent treatment plant comprising:

- (a) a first elongate vessel for anoxic metabolism in the presence of biomass-coated particles of effluent contained within the vessel and passing therethrough
10 under substantially plug flow conditions, the first elongate vessel having a substantially vertical first downcomer zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the first
15 elongate vessel, a substantially vertical first riser zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the first elongate vessel, the bottom region of the first
20 downcomer zone communicating with a bottom region of the first riser zone, and first particle-retaining means for retaining biomass-coated particles within the first elongate vessel;
- (b) feed means for supplying to a top region of the
25 first downcomer zone an effluent to be treated;
- (c) first recovery means for recovery from the top of the first riser zone effluent that has passed through the first downcomer zone and then through the first riser zone;
- 30 (d) a second elongate vessel connected downstream from the first elongate vessel for aerobic metabolism in the presence of biomass-coated particles of effluent that has passed through the first elongate

- 5 vessel and that is passing through the second elongate vessel under substantially plug flow conditions, the second elongate vessel having a substantially vertical second downcomer zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the second elongate vessel, a substantially vertical second riser zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the second elongate vessel, the bottom region of the second downcomer zone communicating with a bottom region of the second riser zone, and second particle-retaining means for retaining biomass-coated particles within the second elongate vessel;
- 10 (e) feed means for feeding effluent from the first elongate vessel to a top region of the second downcomer zone;
- 20 (f) gas injection means for injecting an oxygen-containing gas into the second elongate vessel so as at least in part to facilitate and maintain circulation of effluent and biomass-coated particles through the second elongate vessel;
- 25 (g) second recovery means for recovering effluent from the top region of the second riser zone; and
- (h) means for recycling at least a part of the effluent that has passed through the second elongate vessel to a top region of the first downcomer zone.
- 30 In such a plant the biomass-coated particles typically carry a surface coating of adherent bacteria and may further be impregnated with bacteria or have bacteria embedded therein. The effluent and biomass-

coated particles flow down through the first downcomer zone and up through the first riser zone. The effluent after separation from the biomass-coated particles then passes into the second elongate vessel in which it is passed, again in admixture with biomass-coated particles down through the second downcomer zone, and up through the second riser zone. Substantially anoxic conditions for bacteria in the biomass-coated particles are maintained throughout at least a majority of the dwell period of effluent in the first elongate vessel while substantially aerobic conditions are maintained for bacteria in the biomass-coated particles throughout at least a majority of the dwell period of effluent in the second elongate vessel. Hence the biomass-coated particles in the first elongate vessel contain mainly anoxic bacteria while those in the second elongate vessel contain mainly aerobic bacteria. Moreover the overall flow through the plant is under substantially plug flow conditions with recycle.

The feed means for supplying to a top region of the first downcomer zone an effluent to be treated may comprise a header tank communicating with the first downcomer zone.

Preferably the top region of the second downcomer zone has an enclosed connection to the top region of the first riser zone for passage of effluent from the first riser zone into the second downcomer zone. This has the benefit that noxious-smelling fumes cannot escape from the plant in this region.

The plant may further comprise gas venting means for venting nitrogen-containing gases generated in the first elongate vessel.

In one arrangement the feed means to the first

downcomer zone comprises a first header tank, the first elongate vessel further comprises inert gas injection means for injecting inert gas into the first riser zone to facilitate and maintain movement of effluent through
5 the first elongate vessel by a gas-lift pump action and a degassing zone for degassing of effluent emerging from the top of the first riser zone, and the degassing zone communicates with the first header tank to permit recycle of effluent from the degassing zone to the first
10 downcomer zone. In such a plant the first elongate vessel may further comprise gas recovery means for recovering gas from the degassing zone for recycle to the inert gas injection means.

In one preferred embodiment of the invention, at
15 least one of the first and second elongate vessels comprises a pair of lined shafts, each for example from about 2 to about 10 metres in diameter, preferably from about 2 to about 8 metres in diameter, sunk in the ground adjacent to one another to an appropriate depth, for
20 example from about 40 metres to about 150 metres, with a lined tunnel joining the bottom ends thus forming a generally U-shaped vessel, the one shaft providing a downcomer zone and the other providing a riser zone. The areas of cross section of each downcomer and its
25 associated riser zone may be equal to each other or different so that the downward velocity of the effluent in the downcomer zone may be higher than the upward velocity of the mixture of gas and effluent in the corresponding riser zone. For example, the cross
30 sectional areas can be chosen so that the downward velocity of the effluent in a downcomer zone, e.g the second downcomer zone, can be from about 1.2 to about 2.0 metres/sec, whereas the upward velocity in the

corresponding riser zone can be lower, though is preferably at least about 0.5 metres/sec, for example from about 1.2 to about 2.0 metres/sec.

Although it will usually be most practical to sink
5 circular shafts, any other cross section of shaft may be used. Such shafts are conveniently lined with concrete or other suitable lining material. An impervious layer, for example a layer of polyolefin sheet, such as polyethylene or polypropylene sheet, can be incorporated
10 in the lining of the shaft in order to minimise the risk of leakage of effluent from the shaft.

Alternatively, at least one of the first and second elongate vessels may comprise an elongate lined shaft having a partition between the downcomer zone and the
15 riser zone along a major portion of the length of the shaft with the bottom of the partition forming an underflow weir. In yet another embodiment there is provided a single elongate lined shaft having a cruciform partition dividing the interior of the shaft into four
20 respective substantially vertical channels which may be of substantially equal area of cross section to one another or have different areas of cross section. These substantially vertical channels form respectively the first downcomer zone, the first riser zone, the second
25 downcomer zone, and the second riser zone, with one part of the cruciform partition providing an underflow weir between the first downcomer zone and the first riser zone and another part of the cruciform partition separating the first riser zone and the second downcomer zone; this
30 other part can be fully enclosed with a vent gas line for venting gas produced by anoxic bacterial action. Alternatively, the first and second vessels may be defined by three concentric endless partitions located in

a single shaft which thus divide the shaft into four substantially vertical concentric channels; in this case the first downcomer zone can be the central channel within the innermost partition which forms an underflow weir at its lower end, the next outward channel between the innermost partition and the next outward partition forming the first riser zone while that next outward partition defines a the third channel which in turn acts as the second downcomer zone and is separated from the outermost channel by the third partition which acts as an underflow weir, the outermost channel forming the second riser zone. The header space between the first riser zone and the second downcomer zone can be enclosed with a vent gas line for venting gas produced by anoxic bacterial action. In another possible arrangement of such a shaft with three concentric partitions the outermost channel forms the first downcomer zone, the next inner channel the first riser zone, the next inward channel the second downcomer zone, and the innermost channel the second riser zone.

In difficult terrain for sinking shafts part or all of the plant can be built above ground level.

The plant of the invention includes gas injection means for injecting an oxygen-containing gas into the second elongate vessel so as at least in part to facilitate circulation of effluent and biomass-coated particles through the second elongate vessel such that effluent and biomass-coated particles flow down through the second downcomer zone, and up through the second riser zone and, if desired, to assist in maintaining such circulation through the second elongate vessel. Such gas injection means preferably includes means for injecting oxygen-containing gas into the second downcomer zone; it

may further include means for injecting oxygen-containing gas into the second riser zone principally in order to initiate circulation of effluent and biomass-coated particles through the plant by an air-lift pump principle. The point of injection of oxygen-containing gas into the second downcomer zone and into the second riser zone is in each case preferably at a position between 0.1 and 0.4 times its respective total depth. Thus when the zones extend to a depth of from 150 to 250 metres below the surface of the terrain, oxygen-containing gas is injected 15 to 100 metres below this level. It is further preferred that, when the zones are particularly deep, e.g. 100 metres or more, air injection takes place at a position more than 30 metres down the second downcomer zone and the second riser zone respectively. Conveniently the points of injection into the second downcomer and second riser respectively are at depths which are at essentially the same hydrostatic pressure when effluent is circulating. In this way a common oxygen-containing gas supply conduit can be used to supply both gas injection means.

A suitable gas injection means comprises at least one open ended sparge pipe. Alternatively the gas injection means may comprise a flat-shaped tube having a plurality of lateral holes through which gas may be drawn laterally into the circulating effluent. The holes are preferably such as to produce bubbles in the effluent of initial diameter within the range of from about 2 mm to about 8 mm.

Typical oxygen-containing gases include air, oxygen-enriched air and pure oxygen. The use of air is preferred, principally on the grounds of cost.

Instead of using an air-lift pump method of

initiating and maintaining circulation of effluent and biomass-coated particles there can alternatively be used a propeller or propellers, an axial flow pump or pumps, or an axial flow turbine or turbines. However, provision
5 of means for injection of air into the second riser is usually preferred for maintaining circulation of effluent and biomass-coated particles in the plant of the invention.

Movement of effluent through the second elongate
10 vessel can be initiated by initially injecting oxygen-containing gas, e.g. air, into the second riser zone only. The supply of gas to the second riser zone causes movement of effluent by an air-lift pump effect because of the density difference between the mixed gas/effluent
15 (plus biomass-coated particles) combination in the upper part of the second riser zone and the effluent and biomass-coated particles in the second downcomer zone at start up of the plant. This density difference can be as high as 0.2 g/cm^3 . Once the mixture of effluent and
20 biomass-coated particles is moving at a sufficiently high rate air can then be injected also into the second downcomer zone. Eventually, when the effluent velocity in the second elongate vessel reaches about 1.0 metres/second, the supply of oxygen-containing gas to the
25 second riser can be cut off, if desired, so that circulation is maintained solely by the supply of oxygen-containing gas to the second downcomer zone.

The plant of the invention can be constructed so that effluent passes through the first elongate vessel on
30 a "once through" basis and then passes, also on a "once through" basis through the second elongate vessel. In such a plant, which is for convenience hereafter termed a "double once through" plant, there is no recycle of

effluent around either the first elongate vessel or around the second elongate vessel. Instead effluent recovered from the second riser zone of the second elongate vessel can be recycled to the first downcomer zone of the first elongate vessel.

In another form of plant according to the invention effluent is arranged to pass through the first elongate vessel on a "once through" basis and then to pass through the second elongate vessel which is arranged on a recirculating basis with effluent recovered from the second riser zone being recirculated to the top of the second downcomer zone. Such a plant can be termed, for convenience, a "once through anoxic/recirculating aerobic" plant.

In yet another form of plant according to the invention, effluent is arranged to be recycled around the first elongate vessel a plurality of times before passing on to the second elongate vessel around which the effluent is also recycled a plurality of times. Such a plant can be termed, for convenience a "double recirculating" plant.

At start up, each of the elongate vessels in the plant is filled with sewage or other effluent and charged with a charge of suitable particles for promoting biomass growth. Then a charge of sludge (e.g. a truck load of sewage sludge) from an existing treatment plant is dumped into the effluent in one or both of the first and second elongate vessels of the plant in order to "seed" the effluent with aerobic and anoxic bacteria. Initially the effluent is circulated in a closed loop through the plant or in separate loops through the first and second elongate vessels respectively. When the biomass-coated particles in the circulating mixture of effluent and

particles contains adequate populations of aerobic and anoxic bacteria, incoming effluent can be fed to the first elongate vessel of the plant while a corresponding volume of treated effluent can be withdrawn from the
5 second elongate vessel.

The supply of oxygen containing gas to the second vessel serves to maintain the second vessel under conditions effective for aerobic metabolism of the effluent, at least for a majority of the dwell period of
10 effluent in the second elongate vessel. That is to say, aerobic bacteria thrive and multiply on the biomass-coated particles in the second vessel. The first vessel, on the other hand, is not aerated. Thus substantially anoxic conditions for bacteria in the effluent are
15 maintained throughout at least a majority of the dwell period of effluent in the first elongate vessel. The first elongate vessel is thereby maintained under conditions effective for anoxic metabolism of the effluent and the anoxic bacteria thrive and multiply on
20 the biomass-coated particles in this vessel.

In a "double once through" plant according to the invention, the circulation rate through the first and second vessels can be high, so that the dwell time in each vessel is only a matter of a few minutes, for
25 example about 90 seconds to about 5 minutes.

The plant of the invention provides several significant advantages over conventional plants known in the art. Effluent circulating in the plant is highly aerated in the second elongate vessel and can therefore
30 handle a high concentration of biomass. Typically, a plant according to the invention can handle from about 6000 mg to about 20000 mg of biomass per litre of liquid in the plant. This enables the plant to cope efficiently

with a high concentration of incoming effluent. The enhanced aeration of the effluent in the plant, caused by the constant recycling of the effluent through regions of aeration, enables the plant to run at a high f/m ratio
5 (food/microorganism ratio) in comparison with conventional plants. Typically, a plant according to the invention can operate at an f/m ratio of 1.0 per day or higher. This improvement has consequent capital cost advantages since the use of a higher f/m ratio enables a
10 smaller plant to cope with the same quantity of effluent as a larger plant operating at a lower f/m ratio.

A further advantage of the plant of the invention is that, due to the high liquid velocities in the downcomers and risers, there is a reduced risk of solid materials to
15 settling out of the effluent and clogging the reactor.

The provision of the first elongate vessel operating under substantially anoxic conditions avoids the attendant disadvantages of prior art denitrification tanks, in which the residence time of the effluent is a
20 number of hours. The residence time of the effluent in the anoxic region of the plant of the invention, i.e. the first elongate vessel, is an order of magnitude less than this, depending on the size of the plant and the recycling rate of the effluent. In a "double once
25 through" plant the residence time in each of the first and second elongate vessels on each cycle of effluent through the plant is of the order of a few minutes only, for example from about 90 seconds to about 5 minutes. This means that the aerobic bacteria in the recycle
30 stream are not destroyed but merely subdued, the bacteria once again thriving upon entering the aerated second vessel. Similarly, anoxic bacteria are merely subdued while passing through the aerated second vessel and

recommence to thrive when recycled to the first vessel. However, the effluent is normally recycled many times through the first and second vessels so that the overall treatment time under anoxic and aerobic conditions
5 respectively is measured in hours, for example from about 30 minutes up to about 5 hours.

The plant of the invention may further comprise a degassing tank for recovery of effluent from the riser zone of the second vessel and for allowing degassing of
10 such effluent. In this case, the plant may be arranged such that the means for recycling at least a portion of effluent in the riser zone of the second vessel to the downcomer zone of the first vessel comprises means for recycling at least a portion of effluent recovered in the
15 degassing tank to the first downcomer zone of the first elongate vessel. Since the air/effluent mixture has a lower density than that of the effluent alone, the degassing tank can be arranged so that the surface of the degassing effluent is at a height above the level of the
20 surface of effluent in the header tank to the first downcomer zone; in this way the degassed effluent that is being recycled can flow under gravity back into that header tank. A treated effluent stream can be withdrawn from the degassing tank for further treatment, e.g.
25 filtration and clarification.

The invention further provides a process for the treatment of effluent comprising:

- (a) providing a first elongate vessel for anoxic
30 metabolisation in the presence of biomass-coated particles of effluent contained within the vessel, the first elongate vessel having a substantially vertical first downcomer zone for transport of effluent and biomass-coated particles under

- substantially plug flow conditions towards a bottom region of the first elongate vessel, a substantially vertical first riser zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the first elongate vessel, the bottom region of the first downcomer zone communicating with a bottom region of the first riser zone, and first particle-retaining means for retaining biomass-coated particles in the first elongate vessel;
- (b) supplying to a top region of the first downcomer zone an effluent to be treated at a feed rate corresponding to a dwell time in the first elongate vessel of from about 90 seconds to about 5 minutes;
- (c) allowing the effluent and biomass-coated particles to pass under substantially plug flow conditions through the first elongate vessel;
- (d) recovering from the top of the first riser zone effluent that has passed through the first downcomer zone and the first riser zone;
- (e) providing a second elongate vessel for aerobic metabolism in the presence of biomass-coated particles of effluent, the second elongate vessel having a substantially vertical second downcomer zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the second elongate vessel, a substantially vertical second riser zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the second elongate vessel, the bottom region of the second downcomer zone communicating with a bottom region of the second

riser zone, and second particle-retaining means for retaining biomass-coated particles into second elongate vessel;

- 5 (f) feeding effluent from the first elongate vessel to a top region of the second downcomer zone;
- (g) injecting an oxygen-containing gas into the second elongate vessel so as at least in part to facilitate and maintain circulation of effluent and biomass-coated particles through the second elongate vessel;
- 10 and
- (h) recovering effluent from the top region of the second riser zone.

In order that the invention may be clearly understood and readily carried into effect, some preferred embodiments thereof and their use will now be described with reference to the accompanying drawings, in which:-

15

Figure 1 is a flow diagram of a liquid effluent treatment plant constructed and arranged in accordance with the invention;

20

Figure 2 is a flow diagram of a second form of liquid effluent treatment plant constructed and arranged in accordance with the invention; and

Figures 3 to 6 are horizontal sections through alternative forms of liquid effluent treatment plant.

25

Referring to Figure 1 of the drawings, there is shown a liquid effluent treatment plant 1 for treatment of a liquid effluent using an active biomass in the form of coated particles. This active biomass can comprise, for example, microorganisms immobilised in or on organic gel beads, such as polyacrylamide beads or alginate beads, or supported on mineral particles, such as clay particles. Such particles further are or become coated

30

with bacteria. The coated particles are preferably of approximately neutral or slightly negative buoyancy. Hence they preferably have a density in the range of from about 0.9 to about 1.1 g/ml. If the particles or beads
5 have ionic groups on their surface, then the adhesion of bacteria, which carry a charge on their surface, can be improved.

The effluent is typically a domestic effluent or sewage and may contain suspended solids therein.
10 However, it may alternatively be an industrial effluent or other kind of liquid effluent, e.g. polluted river water or stream water from a tributary which is to be treated before being returned to the flow of a main watercourse.

15 The liquid effluent is supplied from an outside source (not shown), e.g. a sewer, via line 2 into a header tank 3 which forms the top part of a first downcomer 4 which forms part of a generally U-shaped first elongate vessel 5. Vessel 5 is pre-loaded with a
20 charge of biomass-coated particles.

Conveniently downcomer 4 is formed by a lined shaft, typically from 3 to 8 metres in diameter, sunk in the ground to a depth of from about 40 to about 100 metres. This is linked at its bottom by a transverse tunnel (as
25 indicated at 6) to an adjacent lined shaft 7 which forms a first riser and is also part of the first elongate vessel 5. The top of first riser 7 is provided with a header tank 8 which has a vertical grille 61, the top edge of which serves as a weir. The apertures in grille
30 61 are sized so as to retain the biomass-coated particles in header tank 8. Effluent flows through the grille 61 or over its top edge into a hopper device 62 which is either incorporated into, or is located adjacent to,

header tank 8. Effluent exits hopper device 62 in line 122. Biomass-coated particles which pass over the top of grille 61 settle out in hopper device 62 under gravity and are returned to downcomer 4 via aperture 63 at the bottom of grille 61 by means of conduit 64 (which is shown in broken lines in Figure 1).

The header tank 3 and first downcomer 4 are separated from header tank 8 and first riser 7 by a barrier 15. Since the surface 16 of the effluent in header tank 3 is higher than the surface 17 of the effluent in header tank 8, which is in turn determined by the height of weir formed by the top edge of grille 61 and the position of the connection with line 122 to hopper device 62, effluent will pass through the first elongate vessel 5 under gravity and through, or over the top of, grille 61 into hopper device 62 and out into line 122.

From hopper device 62 liquid effluent flows in line 122 into one end of header tank 118 at the top of a second downcomer 11 which is of a similar size to first downcomer 4 and forms part of a generally U-shaped second elongate vessel 12. The bottom of second downcomer 11 is connected by a transverse tunnel 13 to the bottom of second riser 14 which also forms part of second elongate vessel 12.

Air or oxygen-enriched air is supplied to the plant from line 18 by means of pump 19 which feeds line 20. Line 20 has two branches 21 and 22 fitted with respective control valves 23 and 24. Branch 21 leads to a gas injection device 25 in second downcomer 11 and branch 22 leads to a corresponding gas injection device 26 in second riser 14. Injection devices 25 and 26 are typically at least 30 metres below ground level and can

be positioned such that, when the plant is in full operation, the hydrostatic pressure at the two injection points are approximately equal. A mixture of effluent and air exits the top of second riser 14 into the other
5 end of header tank 118 where it undergoes degassing.

Barrier 48 separates downcomer 11 from riser 12 and is fitted at its top end with a horizontal baffle 117. Effluent from riser 12 can pass over the top of horizontal baffle 117 for another pass through downcomer
10 11 and riser 12.

Degassed effluent passes through a grille 71 into a hopper device 72 which is either incorporated into, or is located adjacent to, header tank 118. The apertures in grille 71 are sized so as to retain the biomass-coated
15 particles in header tank 118. The top edge of grille 71 acts as a weir. Biomass-coated particles that overflow the weir formed by the top edge of grille 71 settle out under gravity in hopper device 72 and are returned to vessel 12 via aperture 73. A stream of degassed treated
20 effluent passes from hopper device 72 by way of line 28; part of this stream is fed by way of line 29 to a central part of a settling tank 33, which is provided with an annular baffle 34 and with a drive 35. Baffle 34 acts as an underflow weir. Clarified effluent is drawn off from
25 a settling part of tank 33 exterior to annular baffle 34 in line 36. Settled solids can be discharged from the plant in line 41.

The remainder of the degassed effluent in line 28 can be recycled to line 2 in lines 42 and 43 under the
30 influence of pump 44. This contains sufficient organic carbon (i.e. BOD) to satisfy conditions for denitrification in the first elongate vessel 5.

Gas generated in first elongate vessel 5 can be

vented via line 202 from headspace 203. Similarly gas from headspace 119 of header tank 118 can be vented in line 121.

5 In some geographic regions, the geology may prevent the shafts extending below a certain depth. If a reactor of a certain size is required in such a situation then the desired size of the reactor may be achieved by corresponding increase in the bore of the shafts 4, 7, 11 and 14 which may be made larger to compensate for lack of
10 depth. Alternatively a part of each of the elongate vessels 5 and 12 can be constructed above ground and the remainder sunk in the ground, or both elongate vessels 5 and 12 can be wholly constructed above ground.

At the start of operation of the plant 1, the first
15 and second elongate vessels 5 and 12 are filled with effluent from line 2. A charge of biomass-coated particles, e.g. polyacrylamide gel beads coated with a mixture of aerobic and anoxic bacteria, is tipped into each vessel. Alternatively a charge of suitable
20 particles, e.g. polyacrylamide beads, is introduced into each of the vessels 5 and 12 and then a lorry load of sewage sludge from another sewage plant is tipped into the header tank 3, or into each of the header tanks 3 and 118, so as to ensure that the effluent circulating
25 through the first and second elongate vessels 5 and 12 is seeded with suitable aerobic and anoxic bacteria for digestion of the biologically degradable matter in the effluent. These bacteria can then coat and grow on or within the particles.

30 With valve 23 closed and valve 24 open, compressed air is then supplied by pump 19 by way of line 20 and branch 22 and injection device 26 to second riser 14 from lines 18. Valve 23 prevents simultaneous supply of

compressed air to second downcomer 11. This causes effluent to flow up second riser 12 due to an air-lift pump effect and thus draws effluent down second downcomer 11. By supplying compressed air in second riser 14 a significant difference in density between the effluent in second downcomer 11 and that of the air-effluent mixture in riser 14 can be procured, possibly as much of a difference as 0.2 g/cm^3 . When the effluent in shafts 11 and 14 has begun to circulate, valve 23 can be opened somewhat to allow air to be injected into the downwardly flowing effluent in second downcomer 11. When the downward velocity of the effluent in second downcomer 11 exceeds a value equal to the upward velocity of a bubble in the effluent under static conditions, the bubbles of air supplied by way of injection device 25 to second downcomer 11 are dragged downwardly and into second riser 14 by the circulating effluent. When the downward effluent velocity in second downcomer 11 reaches a suitable operating value, typically at least about 1.0 metres/second, the supply of compressed air to second riser 14 via injection device 26 can, if desired, be shut off, its function to initiate circulation of the effluent having been achieved. Normally, however, it will be desirable to continue to supply air through both of the injection devices 25 and 26. Effluent circulates through shafts 11 and 14 and the resulting air/effluent mixture passes into the right hand end of header tank 118, as depicted in Figure 1, where it degasses. At least a portion of the degassed effluent is then recycled to line 2 by way of lines 28, 42 and 43 so as to cause flow of effluent under gravity through first elongate vessel 5 and recycle back to second elongate vessel 12 via line 122.

Once the effluent has been circulated through the first and second elongate vessels 5 and 12 for a sufficient period to allow growth of anoxic bacteria on the particles in vessel 5 and aerobic bacteria on the particles in vessel 12, part of the degassed treated effluent is withdrawn in line 29. At the same time fresh effluent can be admitted via line 2 to header tank 3 at a corresponding rate. Treated effluent in line 29 is passed through settling tank 33 before discharge in line 36 to a watercourse.

As the effluent passes through the aerated shafts 11 and 14 of the plant 1, aerobic bacteria on the biomass-coated particles in vessel 12 metabolise organic compounds in the effluent and also convert ammonia to nitrates. When this nitrate-containing effluent is recycled through anoxic shafts 4 and 7, the anoxic bacteria on the biomass-coated particles in vessel 5 metabolise nitrate to nitrogen, which is eventually released in the head space 203 and vented in line 202.

Typically the residence time of the effluent in the first elongate vessel 5 is only a matter of minutes, e.g. from about 90 seconds to about 5 minutes, for example about 3 minutes. Any free aerobic bacteria in the effluent are not deprived of oxygen for a period sufficient to allow the population thereof to diminish significantly. Similarly, the residence time of the effluent in the second elongate vessel 12 is typically of a similar length to that for the first elongate vessel 5. Any free anoxic bacteria are not subjected to adverse conditions in elongate vessels 12 for a sufficient length of time for their numbers to decrease significantly in the effluent. By circulating the effluent a number of times through the plant, for example from about 15 times

up to about 100 times or more, an adequate overall residence time for the effluent in the plant not only under anoxic conditions but also under aerobic conditions can be achieved. The resulting treated effluent in line 5 36 is, under suitable operating conditions, substantially nitrate-free and has a low residual BOD and COD level.

Since the second elongate vessel is deep, typically about 80 m deep, the hydraulic pressure in the transverse tunnel 13 is correspondingly high. This means that the 10 gas pressure in any bubbles reaching this depth from gas distribution device 25 is equally high. As a result the solubility of O_2 in the effluent is greatly increased. Thus O_2 is more readily available to aerobic bacteria in the circulating effluent which results in a corresponding 15 enhancement to the efficiency of the plant 1.

Since the anoxic zone formed by the first elongate vessel 5 and the aerobic zone formed by the second elongate vessel 12 are totally enclosed, any noxious fumes generated, particularly in the anoxic zone, are 20 contained within the plant 1 and their discharge to the environment can be performed in a controlled manner or the vent gases in lines 121 and 202 can be appropriately treated (e.g. by scrubbing with an alkali) prior to discharge to the environment.

25 From time to time, e.g. two or three times per year, it may be necessary to add more particles to each of the vessels 5 and 12.

Since the concentration of mixed liquor suspended solids is increased by attachment of the microorganisms 30 to the beads it is possible to increase the volumetric loading by a factor of, for example, about 5 compared with a plant of similar design but without added beads. Hence a plant of the illustrated type employing beads can

handle a correspondingly higher throughput of effluent than one that does not employ biomass-coated beads. Moreover a plant operating according to the invention can be more compact in design for a given throughput than one
5 that does not employ biomass-coated particles.

A further advantage of the invention is that the mixed liquor suspended solids is largely retained in the vessels 5 and 12 and the amount of waste sludge for disposal is significantly reduced. The area required for
10 secondary solids separation is also greatly reduced. The combined results of these benefits is that the plant has a small footprint and has reduced capital and operating costs.

The beads may be varied in composition according to
15 the nature of the application or type of effluent to be treated. For example, they can be manufactured from clay material, by polymerisation of acrylamides or from alginates to produce beads on which microorganisms can become attached and are encouraged to grow. The beads
20 may be, for example, spheroidal or granular, preferably with a maximum diameter of from about 2 mm to about 5 mm. In order to minimise the energy required to circulate the contents of each elongate vessel 5 or 12 and to ensure that the usual mixing characteristics are not disturbed,
25 the bead loading is preferably controlled to be in the range of from about 5% to about 15% by volume and certainly no more than about 20% by volume.

The plant of Figure 2 has many items in common with that of Figure 1. Accordingly, for the sake of brevity,
30 like items have been identified by like reference numerals in both Figures 1 and 2.

Instead of having separate header tanks 3 and 8 for first downcomer 4 and first riser 7 respectively, in the

plant 101 of Figure 2 the first downcomer 4 and first riser 7 have a common header tank 102. At the top of vertical barrier 103 there is provided a horizontal baffle 104. Gas, mainly N_2 , evolved in first elongate vessel 5 is extracted in line 105 from the headspace 106 above the surface 107 of the effluent in header tank 102. Additional N_2 can be introduced by way of line 108 into the gas in line 105 and the combined gas stream pumped by pump 109 through line 110 which divides into two branches 111 and 112 which are provided with respective valves 113 and 114. Branch 111 leads to gas injection device 115 in first downcomer 4 while branch 112 leads to a further gas distribution device 116 in first riser 7.

One difference between the plants of Figures 1 and 2 is that in the plant 101 of Figure 2 the connection of line 2 to header tank 102 is at the same level as the connection with line 122 and with the top edge of grille 61.

In the second elongate vessel 12 the barrier 48 is surmounted by a horizontal baffle 117 in a common header tank 118. Gas from the air/effluent mixture debouching from the second riser 14 is vented from the head space 119 above the surface 120 of effluent in header tank 118 by way of line 121.

Effluent from header tank 102 can be passed to header tank 118 in line 122 having passed through, or over, grille 61 into hopper device 62. Similarly effluent from header tank 118 can pass via lines 28 and 29 to settling tank 33, having passed through, or over, grille 71.

At start-up of plant 101, the first elongate vessels 5 and 12 are filled with effluent and with a charge of suitable beads before header tank 102 is charged with a

tanker load of sewage sludge. Then N_2 is pumped from line 108 by pump 109 through line 110 and branch 112 (with valve 114 open) to gas injection device 116; during this time valve 113 is closed. Effluent then begins to
5 circulate through first elongate vessel 5 due to the density difference between effluent in first downcomer 4 and the air/effluent mixture in first riser 7. Gas emerging into the headspace 106 is recirculated via lines 105 and 110 under the influence of pump 109. Effluent
10 emerging from the top of first riser 7 can overflow horizontal baffle 104 back into the top of first downcomer 4.

Circulation of effluent in second elongate vessel 12 is achieved in the same manner as in vessel 12 of the
15 plant of Figure 1.

When the effluent has been circulated an adequate number of times through first elongate vessel 5 for anoxic bacteria on the biomass-coated particles to break down as much as possible of the nitrates in the effluent,
20 some is drawn off from header tank 102 in line 122 while a corresponding quantity is introduced via line 2 into header tank 102.

Second elongate vessel 12 is operated in a similar manner to that used for plant 1 of Figure 1. Gas from
25 the air/effluent mixture from second riser 14 collects in headspace and is removed via line 121 while the effluent component can pass over horizontal baffle 117 back into the top of second downcomer 11. The effluent is circulated through the second downcomer 11 and second
30 riser 14 a sufficient number of times to reduce its BOD and COD levels to a low value.

Figures 3 to 5 show horizontal cross sections through alternative designs for the first elongate vessel

5. The same designs can also be used for the second elongate vessel 12. In Figure 3 the first elongate vessel 5 has a central annular insert 301 which separates the downcomer 4 from riser 7. In the design of Figure 4 a U-tube is installed in a vertical outer shaft, the arms 302 and 303 of the U-tube providing the downcomer 4 and riser 7 respectively. Figure 5 shows an arrangement in which a vertical shaft is divided by a dividing wall 304 which is mounted asymmetrically in the vertical shaft so as to provide a greater area of cross section in the riser 7 for the ascending mixture of air bubbles and effluent, which has a lower density than the effluent itself, than for the descending effluent in the downcomer 4.

In Figure 6 there is shown a design for a plant in which a single vertical shaft houses both the first elongate vessel 5 and also the second elongate vessel 12. This has two vertical dividing walls 305 and 306 in a cruciform arrangement.

It will further be appreciated by those skilled in the art that the settling tank 33 can be replaced by a flotation clarifier.

CLAIMS:

1. An effluent treatment plant comprising:
 - (a) a first elongate vessel for anoxic metabolisation in the presence of biomass-coated particles of effluent contained within the vessel and passing therethrough under substantially plug flow conditions, the first elongate vessel having a substantially vertical first downcomer zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the first elongate vessel, a substantially vertical first riser zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the first elongate vessel, the bottom region of the first downcomer zone communicating with a bottom region of the first riser zone, and first particle-retaining means for retaining biomass-coated particles within the first elongate vessel;
 - (b) feed means for supplying to a top region of the first downcomer zone an effluent to be treated;
 - (c) first recovery means for recovery from the top of the first riser zone effluent that has passed through the first downcomer zone and then through the first riser zone;
 - (d) a second elongate vessel connected downstream from the first elongate vessel for aerobic metabolisation in the presence of biomass-coated particles of effluent that has passed through the first elongate vessel and that is passing through the second elongate vessel under substantially plug flow conditions, the second elongate vessel having a substantially vertical second downcomer zone for

- transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the second elongate vessel, a substantially vertical second riser zone for
- 5 transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the second elongate vessel, the bottom region of the second downcomer zone communicating with a bottom region of the second riser zone, and
- 10 second particle-retaining means for retaining biomass-coated particles within the second elongate vessel;
- (e) feed means for feeding effluent from the first elongate vessel to a top region of the second
- 15 downcomer zone;
- (f) gas injection means for injecting an oxygen-containing gas into the second elongate vessel so as at least in part to facilitate and maintain circulation of effluent and biomass-coated particles
- 20 through the second elongate vessel;
- (g) second recovery means for recovering effluent from the top region of the second riser zone; and
- (h) means for recycling at least a part of the effluent that has passed through the second elongate vessel
- 25 to a top region of the first downcomer zone.
2. A plant according to claim 1, in which at least one of the first and second elongate vessels comprises a pair of lined shafts sunk in the ground adjacent to one another with a lined tunnel joining the bottom ends thus
- 30 forming a generally U-shaped vessel, the one shaft providing a downcomer zone and the other providing a riser zone.
3. A plant according to claim 1 or claim 2, wherein the

areas of cross section of each downcomer and its associated riser zone are selected so that the downward velocity of the effluent in the downcomer zone is higher than the upward velocity of the mixture of gas and effluent in the corresponding riser zone.

4. A plant according to any one of claims 1 to 3, wherein the feed means for supplying to a top region of the first downcomer zone an effluent to be treated comprises a header tank communicating with the first downcomer zone.

5. A plant according to any one of claims 1 to 4, wherein the gas injection means for injecting an oxygen-containing gas into the second elongate vessel includes means for injecting oxygen-containing gas into the second downcomer zone.

6. A plant according to claim 5, wherein the gas injection means further comprises means for injecting oxygen-containing gas into the second riser zone to facilitate initiation of movement of effluent through the second elongate vessel by an air-lift pump action and, if desired, to assist in maintaining same.

7. A plant according to claim 6, wherein the point of injection of oxygen-containing gas into the second downcomer zone and into the second riser zone is in each case at a position between 0.1 and 0.4 times its respective total depth.

8. A plant according to any one of claims 5 to 7, wherein air injection takes place from 15 to 100 metres down the second downcomer zone and down the second riser zone respectively.

9. A plant according to claim 8, wherein the points of injection into the second downcomer zone and into the second riser zone respectively are at depths which are at

essentially the same hydrostatic pressure when effluent is circulating.

10. A plant according to any one of claims 1 to 9,
wherein the gas injection means comprises at least one
5 open ended sparge pipe.

11. A plant according to any one of claims 1 to 10,
wherein the recovery means for recovery of effluent from
the second riser zone comprises a degassing tank for
degassing of effluent.

10 12. A plant according to any one of claims 1 to 11, at
least one of the first particle-retaining means and the
second particle-retaining means comprises a grille.

13. A plant according to claim 12, wherein the apertures
in the grille have a maximum diameter of from about 2 mm
15 to about 5 mm.

14. A plant according to claim 12 or claim 13, wherein
an upper edge of the grille forms a weir over which
effluent may pass.

15. A plant according to any one of claims 12 to 14,
20 wherein a settling zone is provided downstream for
settling of particles that have passed the grille and
wherein means are provided for return of settled
particles to the respective elongate vessel.

16. A plant according to any one of claims 1 to 15,
25 wherein the feed means to the first downcomer zone
comprises a first header tank, wherein the first elongate
vessel further comprises inert gas injection means for
injecting inert gas into the first riser zone to
facilitate and maintain movement of effluent through the
30 first elongate vessel by a gas-lift pump action, and a
degassing zone for degassing of effluent emerging from
the top of the first riser zone, and wherein the
degassing zone communicates with the first header tank to

permit recycle of effluent from the degassing zone to the first downcomer zone.

17. A plant according to claim 16, wherein the first elongate vessel further comprises gas recovery means for recovering gas from the degassing zone for recycle to the inert gas injection means.

18. A plant according to any one of claims 1 to 17, further comprising gas venting means for venting nitrogen-containing gases generated in the first elongate vessel.

19. A plant according to any one of claims 1 to 18 wherein the feed means (b) is arranged to supply an effluent to be treated to the top region of the first downcomer zone at a rate corresponding to a dwell time in the first elongate vessel of from about 90 seconds to about 5 minutes.

20. A plant according to any one of claims 1 to 19, wherein the feed means (d) for feeding effluent from the first elongate vessel to a top region of the second downcomer zone is arranged to supply said effluent at a rate corresponding to a dwell time in the second elongate vessel of from about 90 seconds to about 5 minutes.

21. A process for the treatment of effluent comprising:
(a) providing a first elongate vessel for anoxic metabolism in the presence of biomass-coated particles of effluent contained within the vessel, the first elongate vessel having a substantially vertical first downcomer zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the first elongate vessel, a substantially vertical first riser zone for transport of effluent and biomass-coated particles under substantially

- plug flow conditions towards a top region of the first elongate vessel, the bottom region of the first downcomer zone communicating with a bottom region of the first riser zone, and first particle-retaining means for retaining biomass-coated particles in the first elongate vessel;
- 5
- (b) supplying to a top region of the first downcomer zone an effluent to be treated at a feed rate corresponding to a dwell time in the first elongate vessel of from about 90 seconds to about 5 minutes;
- 10
- (c) allowing the effluent and biomass-coated particles to pass under substantially plug flow conditions through the first elongate vessel;
- (d) recovering from the top of the first riser zone effluent that has passed through the first downcomer zone and the first riser zone;
- 15
- (e) providing a second elongate vessel for aerobic metabolism in the presence of biomass-coated particles of effluent, the second elongate vessel having a substantially vertical second downcomer zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a bottom region of the second elongate vessel, a substantially vertical second riser zone for transport of effluent and biomass-coated particles under substantially plug flow conditions towards a top region of the second elongate vessel, the bottom region of the second downcomer zone communicating with a bottom region of the second riser zone, and second particle-retaining means for retaining biomass-coated particles into second elongate vessel;
- 20
- 25
- 30
- (f) feeding effluent from the first elongate vessel to a

- top region of the second downcomer zone;
- (g) injecting an oxygen-containing gas into the second elongate vessel so as at least in part to facilitate and maintain circulation of effluent and biomass-coated particles through the second elongate vessel;
- 5 and
- (h) recovering effluent from the top region of the second riser zone.

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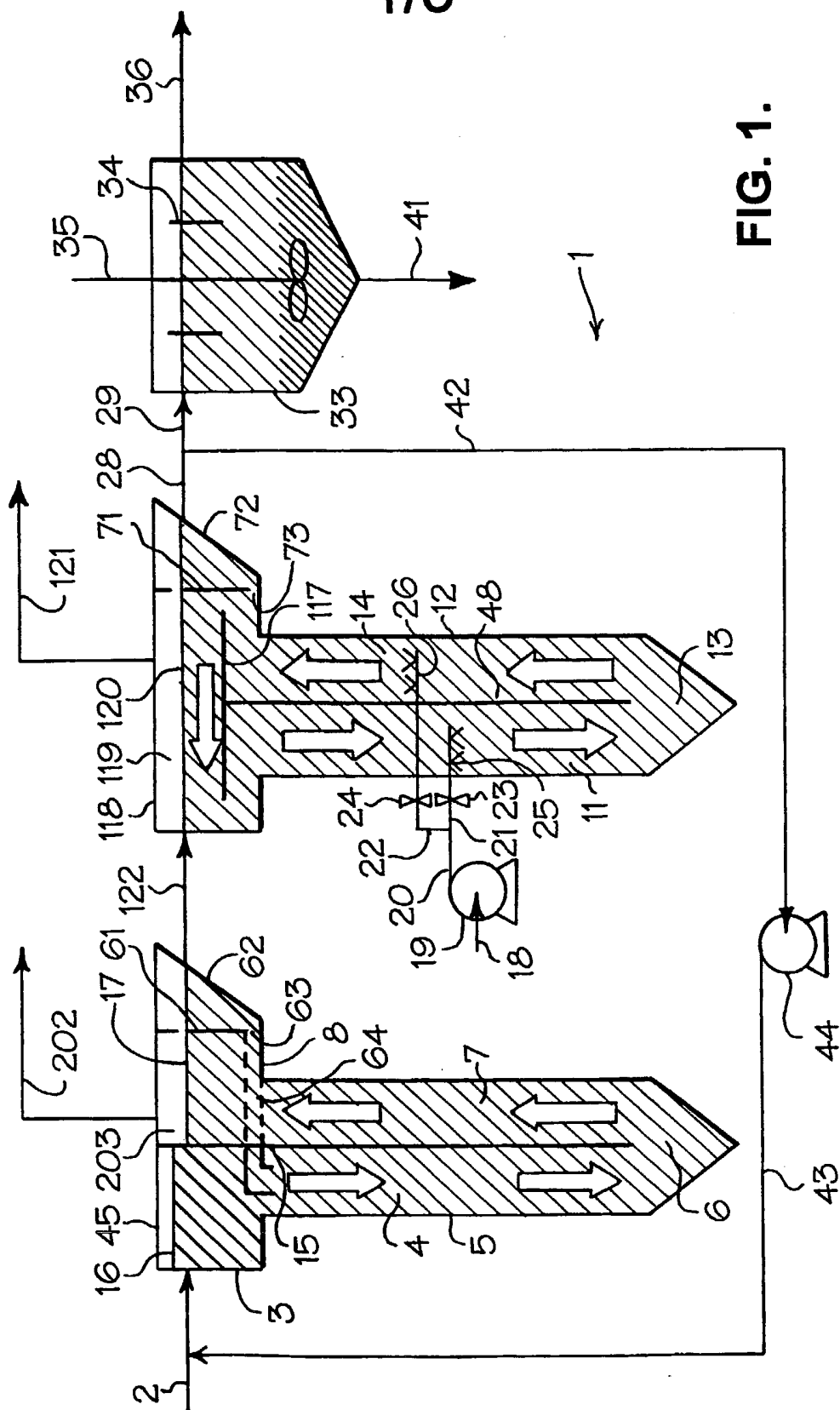


FIG. 1.

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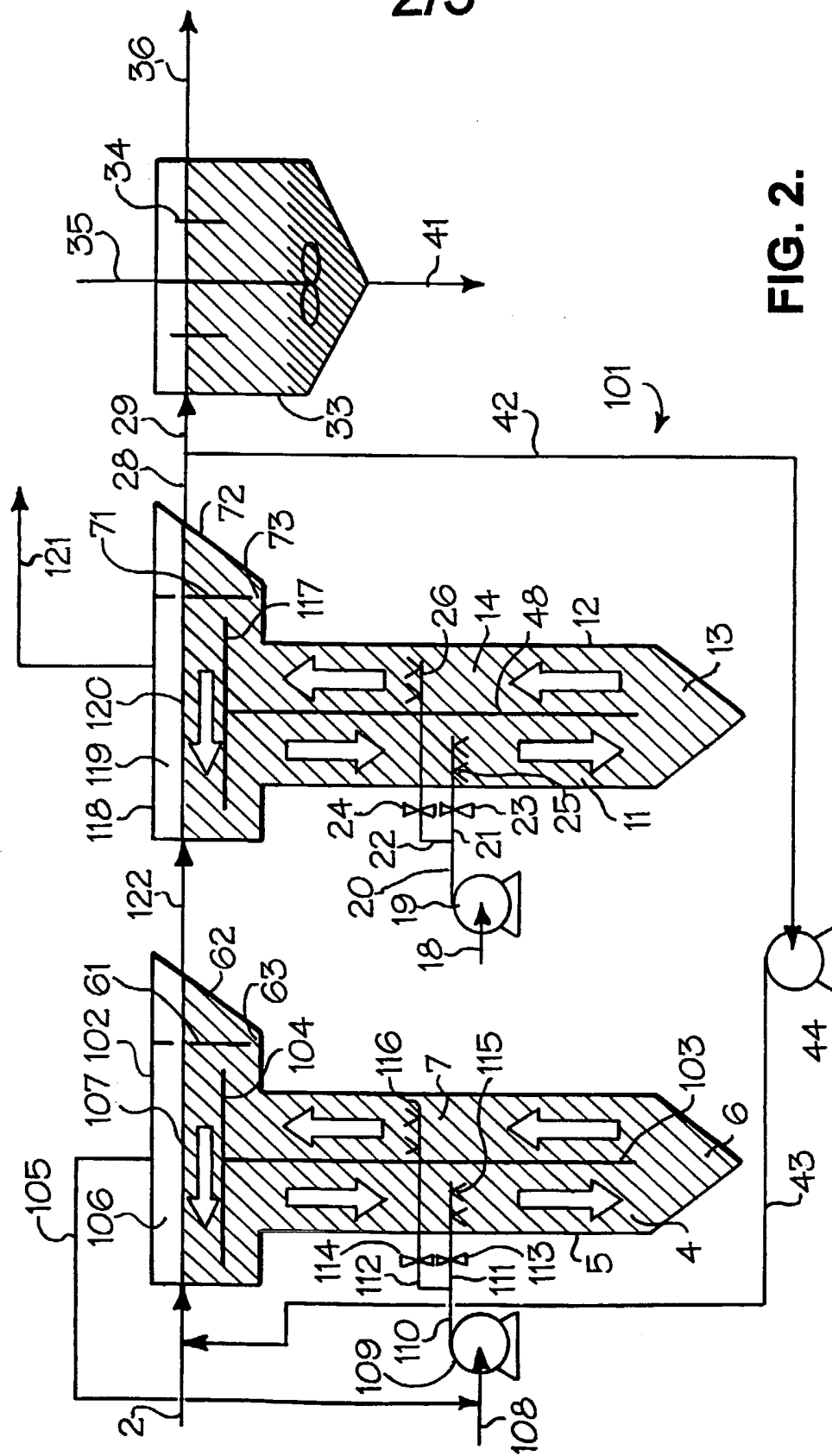


FIG. 2.

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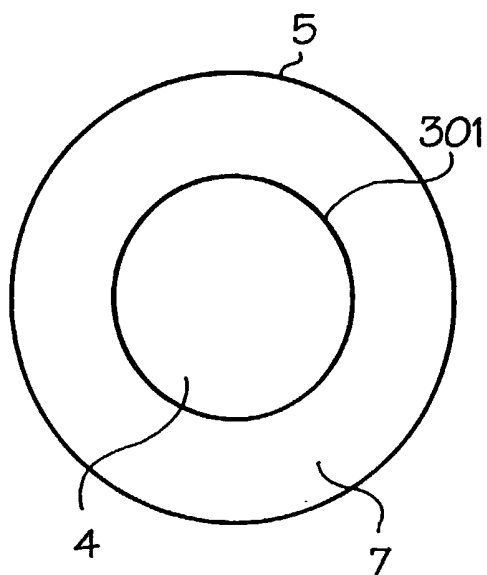


FIG. 3.

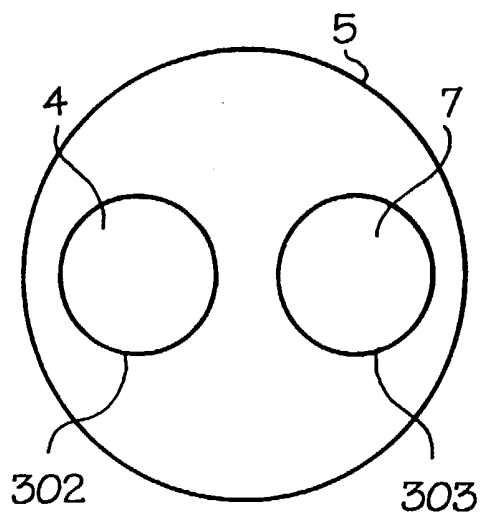


FIG. 4.

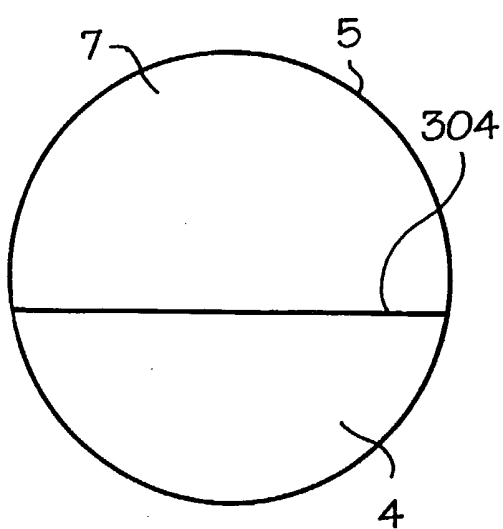


FIG. 5.

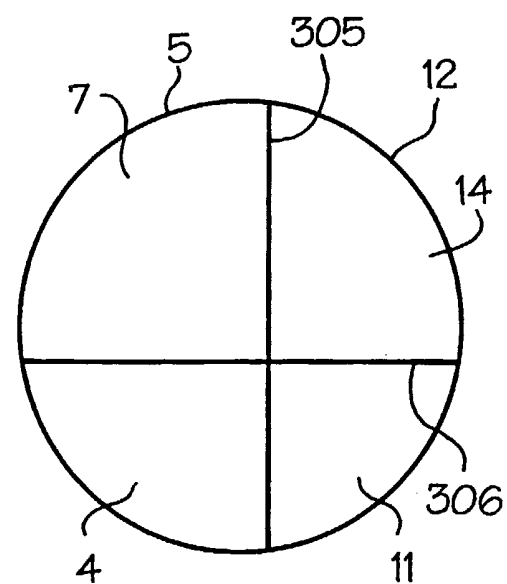


FIG. 6.

INTERNATIONAL SEARCH REPORT

Int. Application No

PCT/GB 99/00779

A. CLASSIFICATION OF SUBJECT MATTER

IPC 6 C02F3/30 C02F3/28 C02F3/22

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 C02F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,X	WO 98 11028 A (JONES RICHARD BERNARD ;WATSON ANDREW JAMES (GB); KVAERNER METALS D) 19 March 1998 (1998-03-19) the whole document	1-11, 16-21
A	PATENT ABSTRACTS OF JAPAN vol. 095, no. 006, 31 July 1995 (1995-07-31) & JP 07 060284 A (MITSUBISHI KAKOKI KAISHA LTD), 7 March 1995 (1995-03-07) abstract	2,21
A	WO 92 19549 A (CUSSONS INT LTD) 12 November 1992 (1992-11-12) the whole document	1,21
	--- -/-	



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

* Special categories of cited documents:

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Date of the actual completion of the international search

28 July 1999

Date of mailing of the international search report

05/08/1999

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INTERNATIONAL SEARCH REPORT

Int. Application No

PCT/GB 99/00779

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 758 680 A (MATSUMURA MASATOSHI ;BIOMATERIAL CO LTD (JP)) 19 February 1997 (1997-02-19) ESPECIALLY PAGES 13 AND 14 AND FIGURES 1,2,9,10	1,21
A	DE 42 01 167 A (LINDE KCA DRESDEN GMBH) 22 July 1993 (1993-07-22) the whole document	1,21
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/GB 99/00779

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